



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

791

D3624-2

Job Sheet 170963



Part No: D3624-2

Job Qty: 2 ea

Part Name: Bubble Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/27/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV D IPP A Thermoform in house 6/27/2007 DL IPP B. Revised due to corrupt operating Program.
7/23/2007 DL IPP C. Dwg. Rev. change 7/30/2007 IPP D. Dwg. Rev. Updated 4/25/2008 verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	2 pcs		2/27/18	0.00	0.00	Purchasing		AT 18/03/25
140	Packaging	2 pcs		2/27/18	0.00	0.00	Packaging2		AT 18/03/25
150	QC	2 pcs		2/27/18	0.00	0.00	QC6		
170	Packaging	2 pcs		2/27/18	0.00	0.00	Packaging3-1		
180	QC21-SA	2 Ea		2/27/18	0.00	0.00	QC21		

Part Op 110 - ISSUE P/O: D3624-2 SUPPLIER: PLASTECB MANUFACTURE D3624-2 AS PER DWG C OF C
Descriptions: IS REQUIRED

JAN 25 2018

2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3624-2P	Bubble Window	2 pcs (1 ea)	110-Purchasing	5054651

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3624-2P	2	0	0

DAS
10
9-88

Macrylics .177
(165F)

Part Specifications

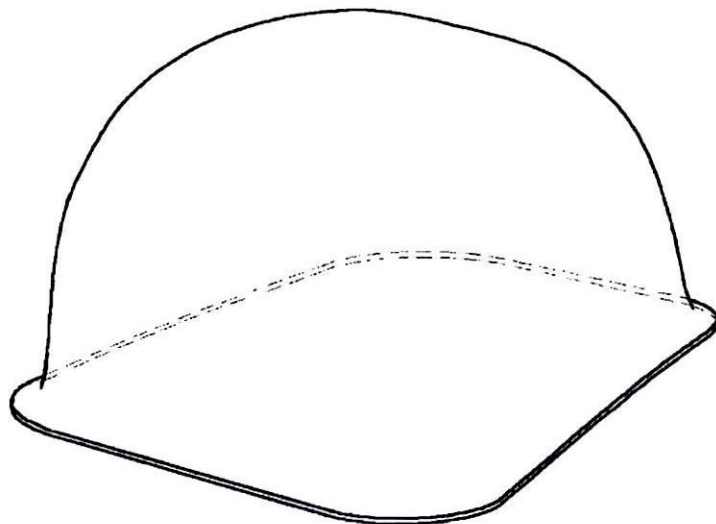
Specifications could not be found.

Plex 1/25/18 7:39 AM dart.lavoie.chantal



PART NO: D3624-2
Serial No/Batch: S054652
Revision:
Operation: Packaging
Change No:

Mfg Date: 03/25/18
Job No: 170963



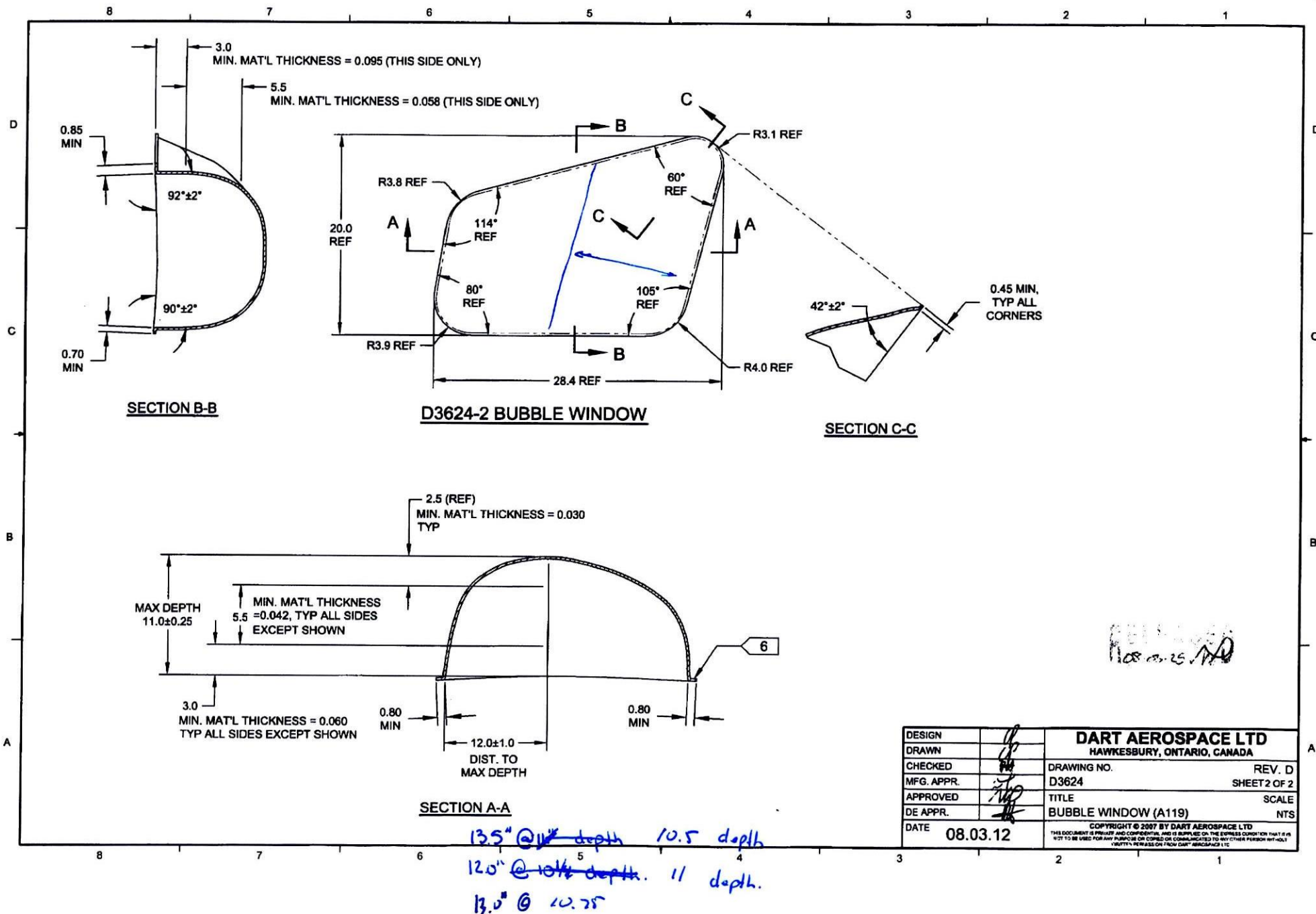
D3624-2 BUBBLE WINDOW

NOTES:

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
0.177 TO 0.188 THICK (STOCK, REF DART SPEC M-ACRYLIC-S)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".
 - 7) WEIGHT: 2.95 lbs
 - 8) FORM PER DT8953 AND QSI 022
- FORMING PROCESS:
- (a) DRAPE OVER DT8953 MOLD
 - (b) HEAT TO 290°F
 - (c) VACUUM FORM TO SPECIFIED HEIGHT
 - (d) LET COOL TO AT LEAST 100°F BEFORE HANDLING
 - (e) TRIM FLANGE USING DT8954

REV.	DESCRIPTION	BY	DATE
D	REDRAW, REFORMAT, RMV SHAPE TOOL, ADD SEC B-B (2C8) & C-C (2C3), ADD FLANGE & WALL & WALL ANGLE DIMS, UPDATE MATL SPEC (1B8)	CP	08.03.12
C	ADD TOOL TO CONTROL BUBBLE SHAPE	CP	07.06.27
B	11.0" DEPTH WAS 12.0"	CP	07.05.24
A	NEW ISSUE	CP	07.06.27

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3624 TITLE BUBBLE WINDOW (A119) COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. D SHEET 1 OF 2 SCALE NTS	
DATE	08.03.12		



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3624	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BUBBLE WINDOW (A119)	NTS
DATE	08.03.12	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038869

Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-436-0004
Fax: 416-736-0010

PO No: PO038869
PO Date: 1/25/18
Due Date: 2/16/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

*Revised
conf price*

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	D3624-2P			Bubble Window As Per Dwg D3624 Rev. D	Firmed	1/16/18	2 pcs	0 pcs 2x	2 pcs AT 1/26/18	\$300.00/pcs	\$600.00

Line Item Note job# 170963

Grand Total: \$600.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

*12
1/26*



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 27828
Shipment Date: 03/22/2018
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
38869
Carrier Account #

Sales Order
SO-022001

Ship Via
FREIGHTCOM INC. -

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number
1Z39WY871497292785

Item Number - Revision Description

D3624-2 - Rev. D BUBBLE WINDOW (A119)
AS PER DWG D3624
HS Code: 3920.51.1000 - OTHER Country of Origin : CA

FREIGHT - FREIGHT

Quantity UOM
Shipped

2 EA

1 EA

Number of Containers

Gross Weight

Shipped By

DART AEROSPACE LTD		Work Order:	
Description: Bubble Window (A119)		Part Number:	D3624-2
Inspection Dwg: D3624 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Bubble Depth within tolerance				
Shape Definition				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:		Date:	
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.0	+/-0.25	11.00"				
3.0	0.095 Min	.107"				
8.5	0.058 Min	.71"				
3.0	0.060 Min	.115"				
8.5	0.042 Min	.74"				
2.5	0.030 Min	.45"				
92°	+/-0.2° Min					
90°	+/-0.2° Min					
0.85	Min	.85"				
0.70	Min	.77"				
12.0	+/- 1.0	13.5"				

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.11.28	New Issue	KJ/DL	

Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Saturday, April 14, 2018

Details			
Raised Date 4/4/2018	Status Open	Owner Williamson, Ryan	Number NCR18-6809
Target Date 6/1/2018	Standard	Severity MAJOR	
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) Engineering	Fault Category General\Fit/Function	
Details during inspection of D3624-2 from PO038869, its was notice that shape of the window was not relevant to drawing.			
Keywords Transpariencies		Product D119-755\D3624-2	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 4/14/2018	Owner Daviau, Marcel	Closed Date 4/6/2018	Closed By Downing, Eric M
Details Drawing does not include sufficient details for supplier to understand the uniformity of the desired shape.			

Actions			
Number	Owner	Target Date	Completed Date
Details	Response		

Corrective Action			
Target Date 6/1/2018	Owner Williamson, Ryan	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
2	Provencal, Chris	6/1/2018	
Recommendation is to create a 3D model and have 3 axis reference go-no-go gauge built on waterjet.			
1	Provencal, Chris	6/1/2018	
review drawing. Drawing lacks information to correctly allow supplier to manufacture part correctly.			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
6/1/2018	Daviau, Marcel		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Verification & Review

Target Date	Owner	Closed Date	Closed By
6/1/2018	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	